



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-012
Job Sheet 174845



Part No: D350-636-012

Job Qty: 1 ea

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/17/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

002416

DART
AEROSPACE
Container No: S056139
Part: D350-636-012
Job No: 174845
Serial No/Batch: S056139
Revision:
Inspector:
Date: 03/28/18

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1270 Aberdeen Street
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CANADA
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Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/16/18	0.00	0.00	Start Up Skid tubes-1		14
110	Skid tubes	1 pcs		4/16/18	0.00	4.36	Skid tubes-4		J.Y. DRE
120	QC	1 pcs		4/16/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs		4/16/18	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs		4/16/18	0.00	0.91	HandFinish1		SA 18-09-03
150	QC	1 pcs		4/16/18	0.00	0.00	QC7-2		BE
160	Skid tubes	1 pcs		4/16/18	0.00	4.36	Skid tubes-1		BE 38 J.Y.
170	QC	1 pcs		4/16/18	0.00	0.00	QC10		9-89 DAS
180	QC	1 pcs		4/16/18	0.00	0.00	QC5		38
190	HandFinish	1 pcs		4/16/18	0.00	0.91	HandFinish2		BA 18-09-03
200	SprayPaint	1 pcs		4/16/18	0.00	0.69	Spray Paint		
205	Outsource	1 pcs		4/16/18			ATE003-VC	PO 39553	Q2 18/04/10
210	QC	1 pcs		4/16/18	0.00	0.00	QC14		ML 18-4-16
230	HandFinish	1 pcs		4/17/18	0.00	0.91	HandFinish4		DAS 8-4-10
240	QC	1 pcs		4/17/18	0.00	0.00	QC5		38
250	Packaging	1 pcs		4/17/18	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		4/17/18	0.00	0.00	QC4		Y.A.D.
265	DC	1 pcs		4/17/18	0.00	0.00	DC		Y.A.D.
270	Packaging	1 pcs		4/17/18	0.00	0.00	Packaging3-1		DAS
280	QC21-FG	1 Ea		4/17/18	0.00	0.00	QC21		21 9-89

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using Uni Jig D26150 & Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 138654 exp. date: 2018-04-21 ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 038611 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2-

PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 11138752 EXP DATE: 10/08 4-

assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: 11133690

265 - record fwd angle: ML3265 Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012

Job BOM			
Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation
D2744	Cap	1 Ea (1 ea)	90-Start up Operation
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish
D2745	Bushing	8 Ea (8 ea)	230-HandFinish
D3488-042	Blade Fitting RH	1 Ea (1 ea)	230-HandFinish
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging
D3493-1	Washer	2 Ea (2 ea)	250-Packaging
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging

002380

Container

5043941

5038835

5033813

5051803

5039269

5040318

5034386

5057153

5019394

FM137055

FM137203

5053267

5007339

5044824

5053631

5037629

5031897

5031935

5058407

5024390

5031903

5041206

5031919

5055240

5052037

5034401

5024236

M138409-121

5036714

5022090

M138441-122

FM137110

5040883

5052854

5040443

5016181

FM105635

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	8	0
	D2744	1	15	0
	D2739	1	25	0
160-Skidtubes	D2743	8	201	0
	D3490-1	4	64	0
	D3490-3	4	47	0
230-HandFinish	ALS4-1032-225	38	1,149	0
	AN3C5A	34	191	0
	AN3C6A	4	330	0
	AN6C44A	4	407	0
	AN8C35A	1	63	0
	D2745	8	225	0
	D3488-042	1	7	0
	D3492-1	8	211	0
	D3492-3	8	144	0
	D3535-25	1	20	0
	D3536-25	1	34	0
	D3537-1	3	153	0
	D3631-1	8	59	0
	D3791-1	1	16	0
	D3793-1	1	20	0
	D3793-3	1	28	0
	D3794-1	1	16	0
	D3794-3	1	44	0
	MS21043-6	4	182	0
	MS21083C8	1	169	0
	NAS1149C0332R	38	4,898	0
	NAS1149C0832R	1	88	0
	NAS1515H3L	4	255	0
	NAS1611-010	8	389	0
250-Packaging	NAS1611-013	8	285	0
	AN8C21A	2	141	0
	D2741	1	67	0
	D3493-1	2	60	0
	D3532-1	2	38	0
	MS21083C8	2	169	0
	NAS1149D0863J	2	147	0
Part Specifications				
Specifications could not be found.				

Plex 3/22/18 9:47 AM Dart.Gagnon.Michelle

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C8A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

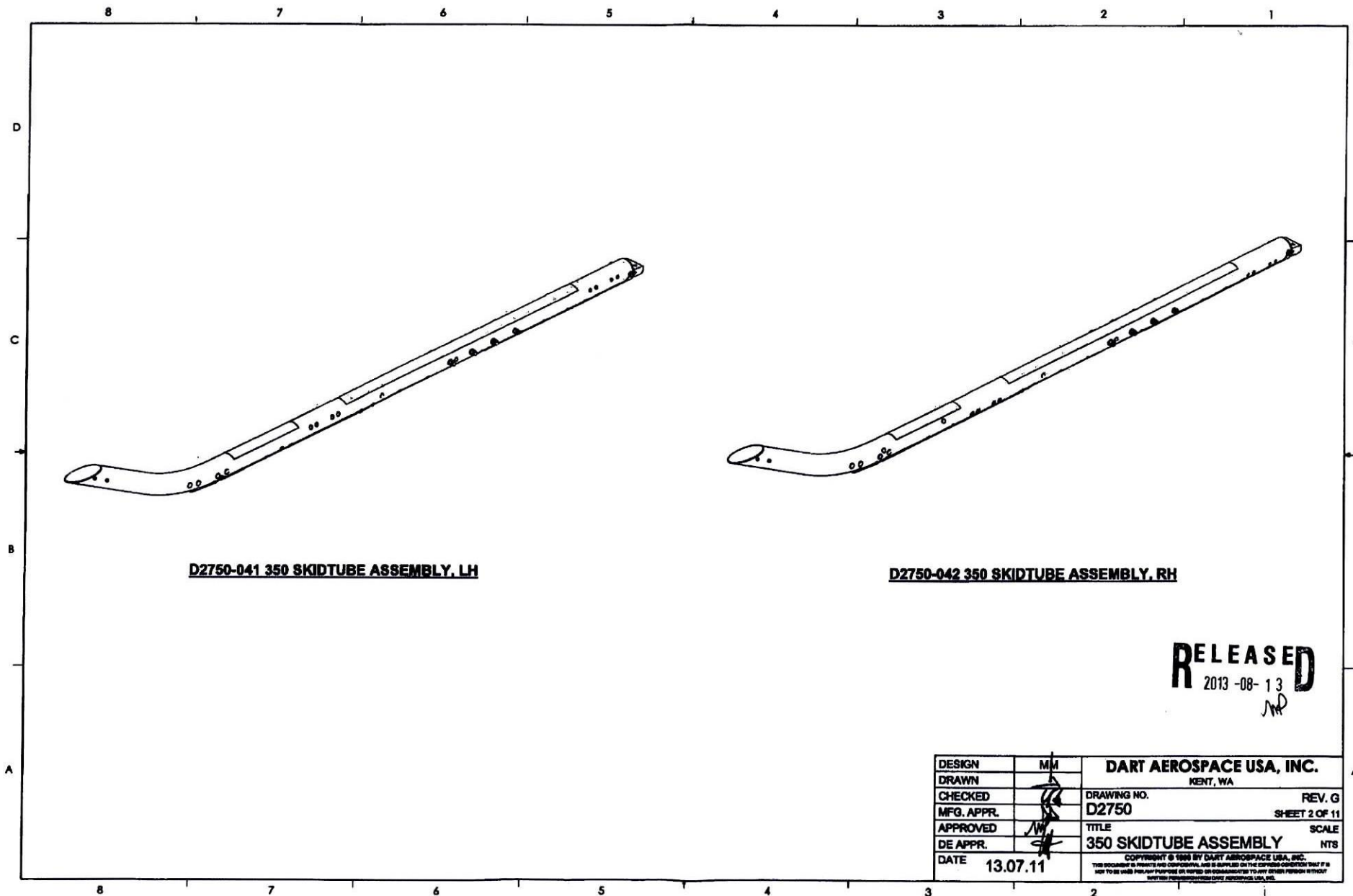
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. 174845
MAR 22 2018

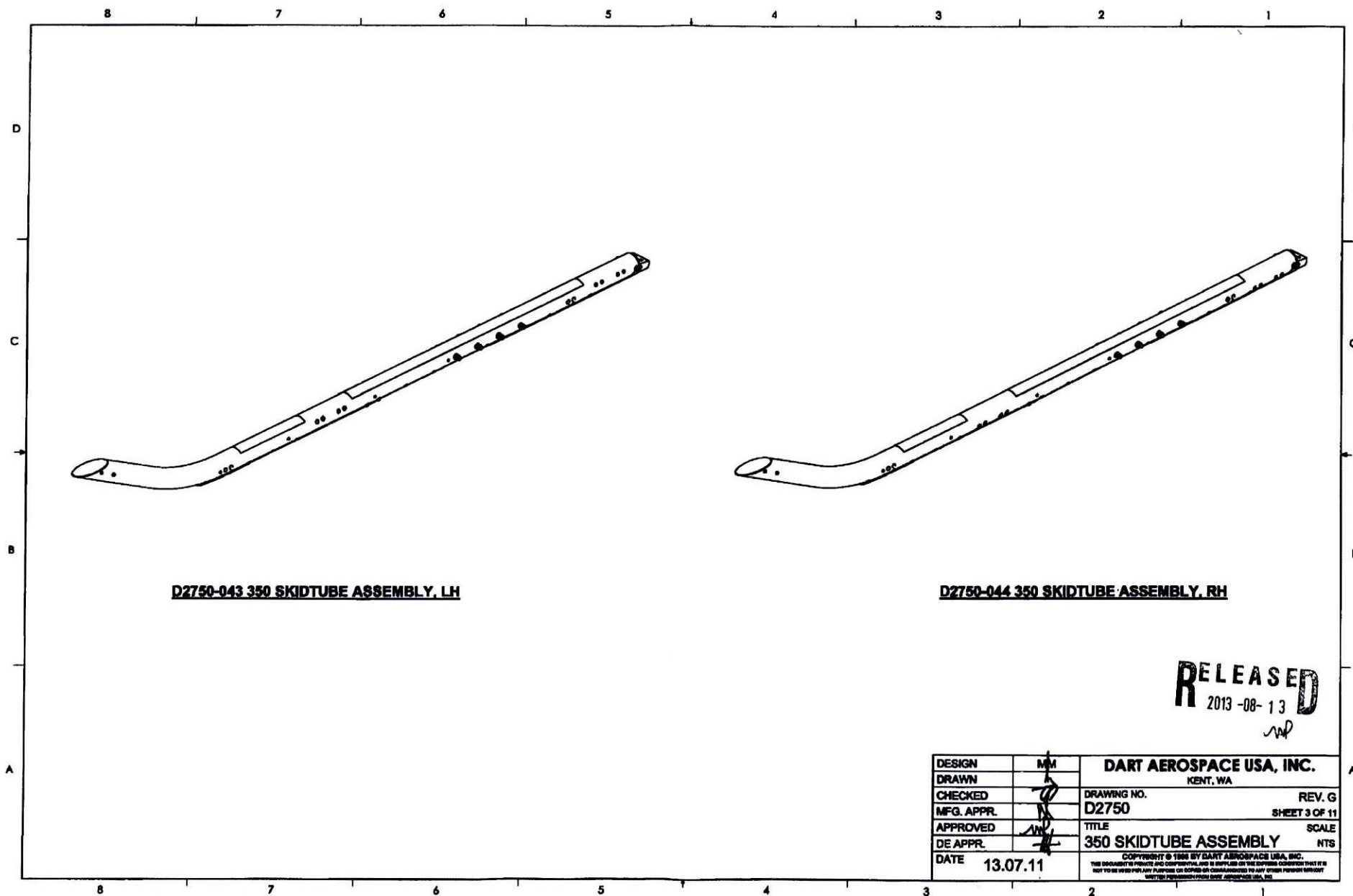
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2013-08-13

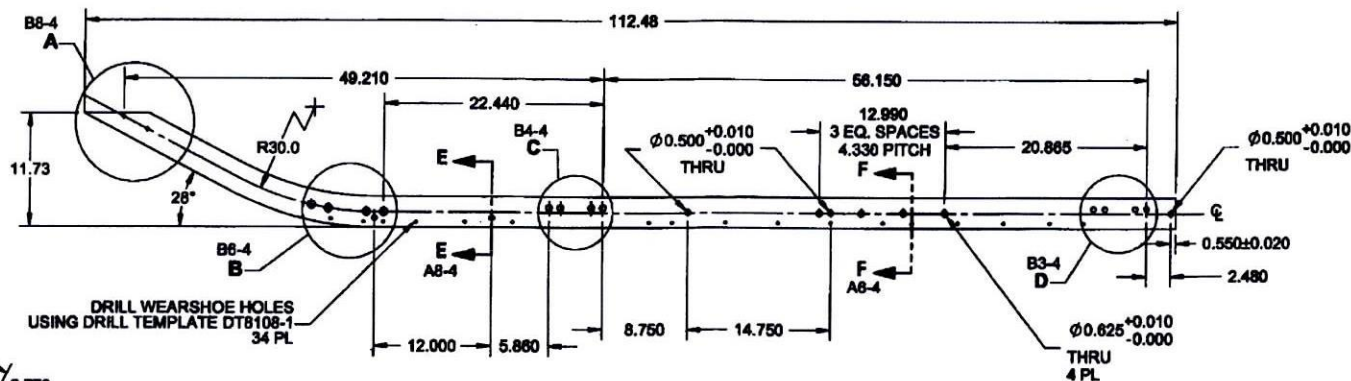
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-8-4/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PARTS-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	06.11.18
B	CHANGE MS24694-S263 TO AN8-16A	CP	06.09.01
A	NEW ISSUE	DS	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	B	KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE OPEN SOURCE BASIS THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



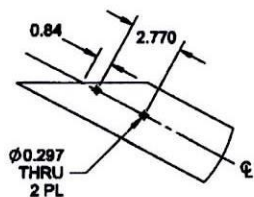
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2013-08-13
MP

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 2 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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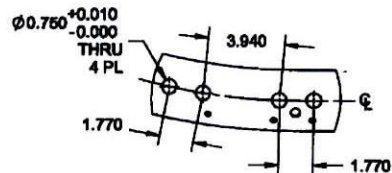




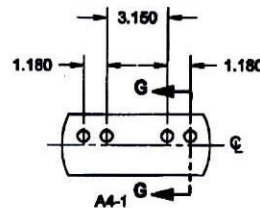
D2750-1 LH SKIDTUBE



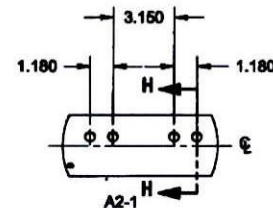
DETAIL A
SCALE 2X



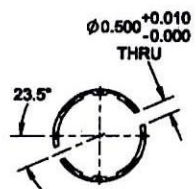
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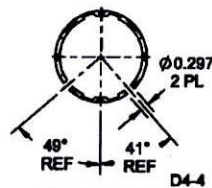
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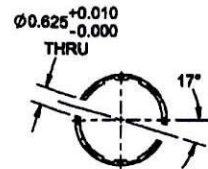
DETAIL D
SCALE 2X



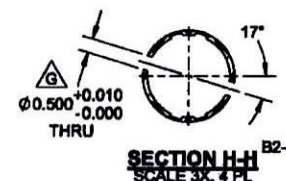
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

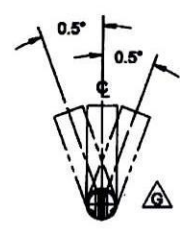
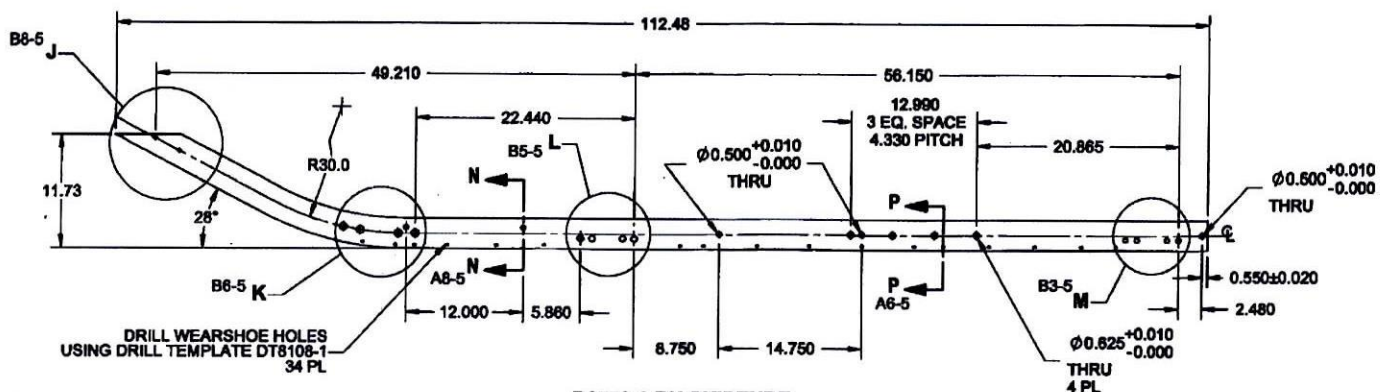


SECTION H-H
SCALE 3X, 4 PL

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2013-08-13

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CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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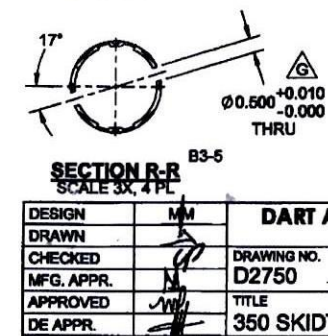
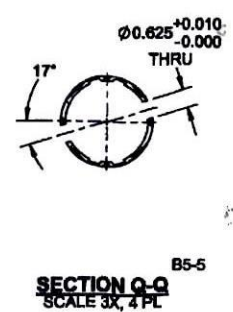
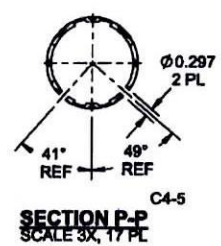
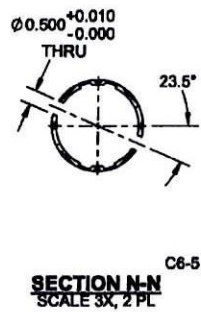
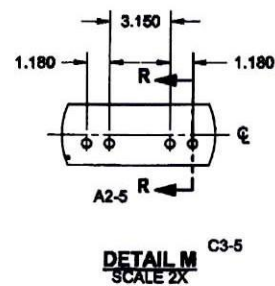
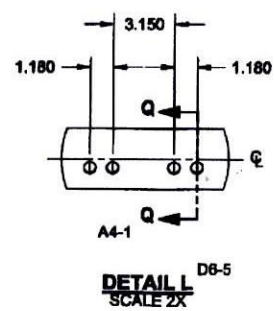
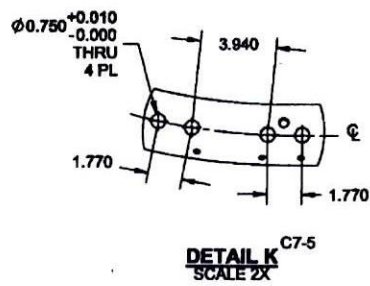
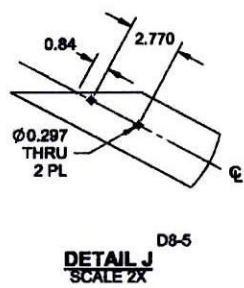
8 7 6 5 4 3 2 1



OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

D2750-2 RH SKIDTUBE

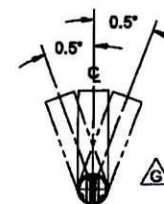
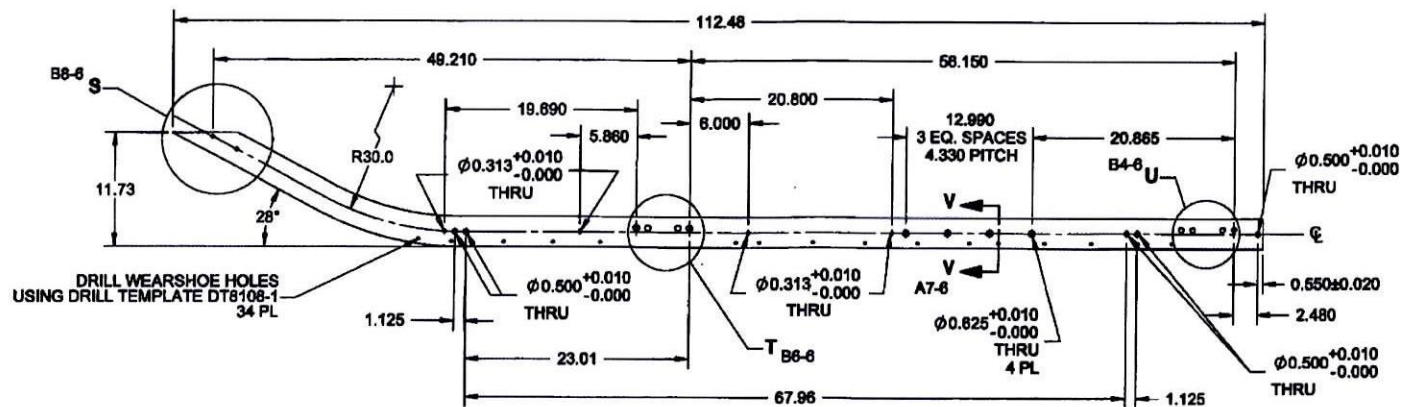


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MFG. APPR.		D2750	SHEET 5 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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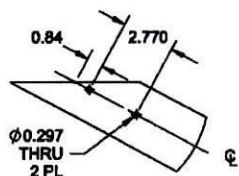
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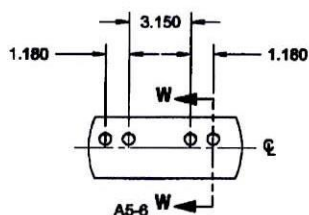


OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

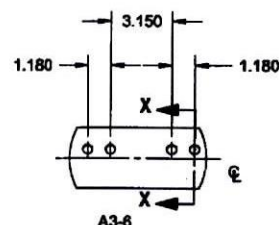
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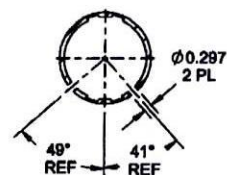
DETAIL S
SCALE 2X
D8-6



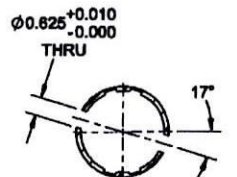
DETAIL T
SCALE 2X
C5-6
A5-6



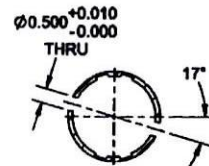
DETAIL U
SCALE 2X
D3-6
A3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6

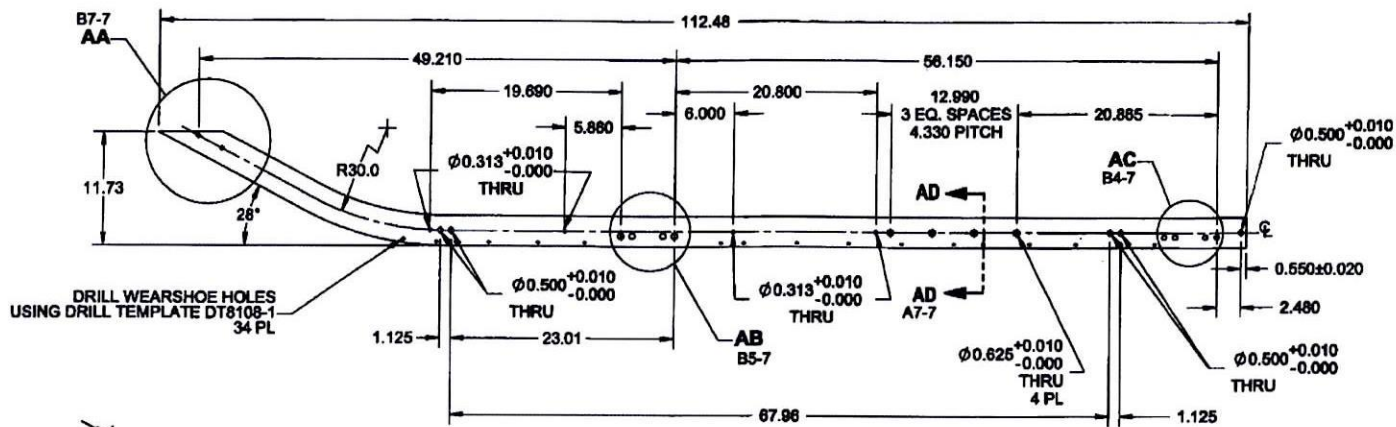


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SCALE 3X, 4 PL
B4-6

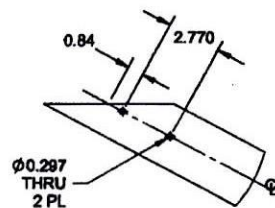
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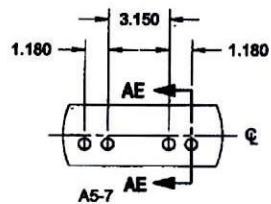
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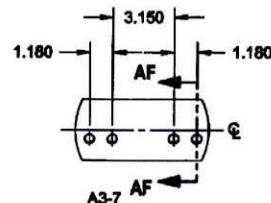
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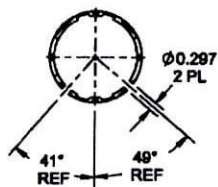
DETAIL AA
D7-7
SCALE 2X



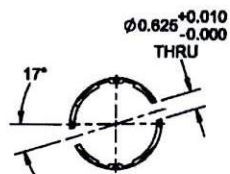
DETAIL AB
C4-7
SCALE 2X



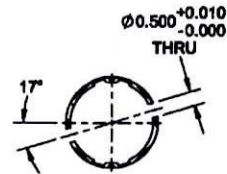
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



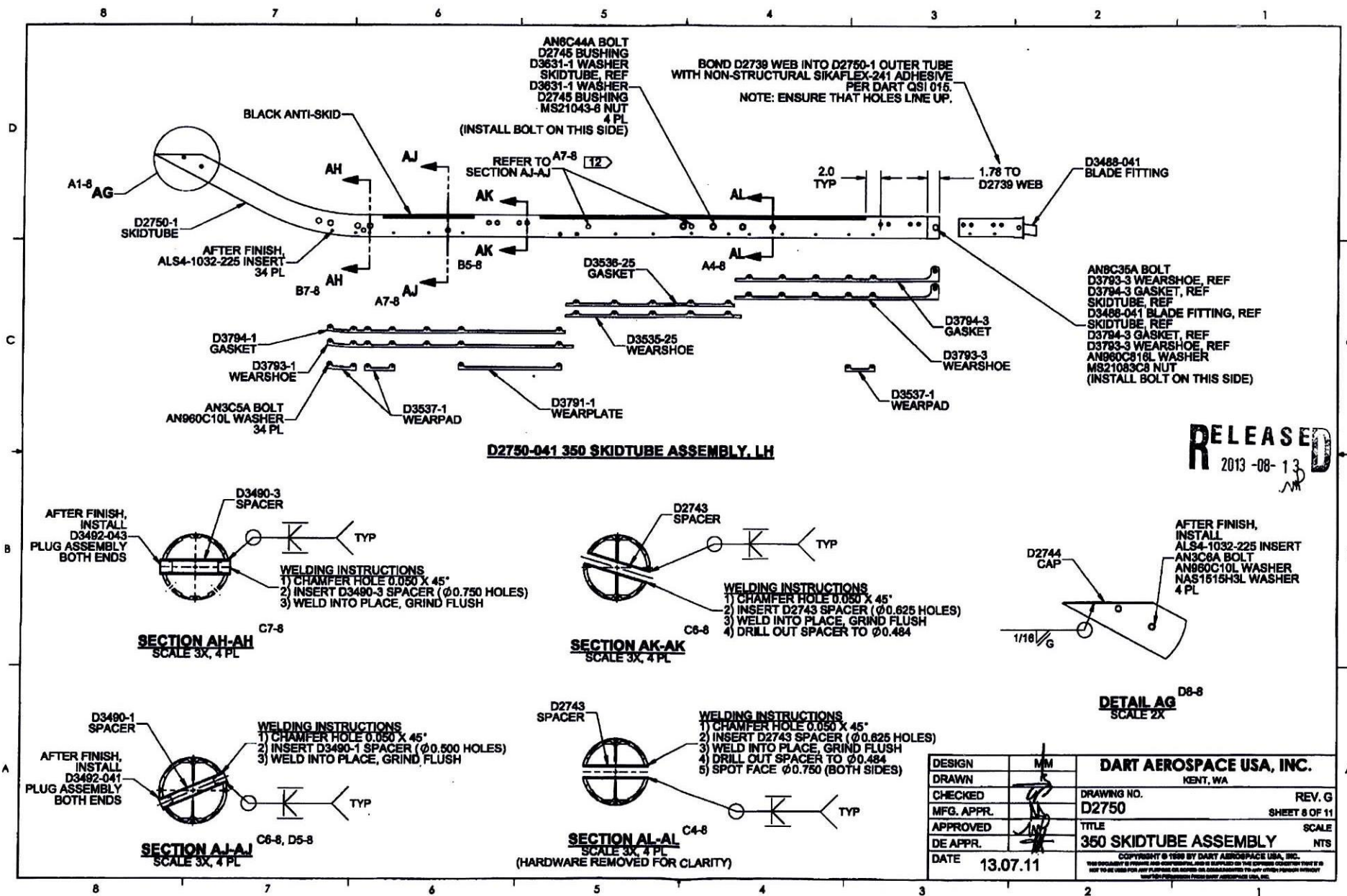
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SCALE 3X, 4 PL

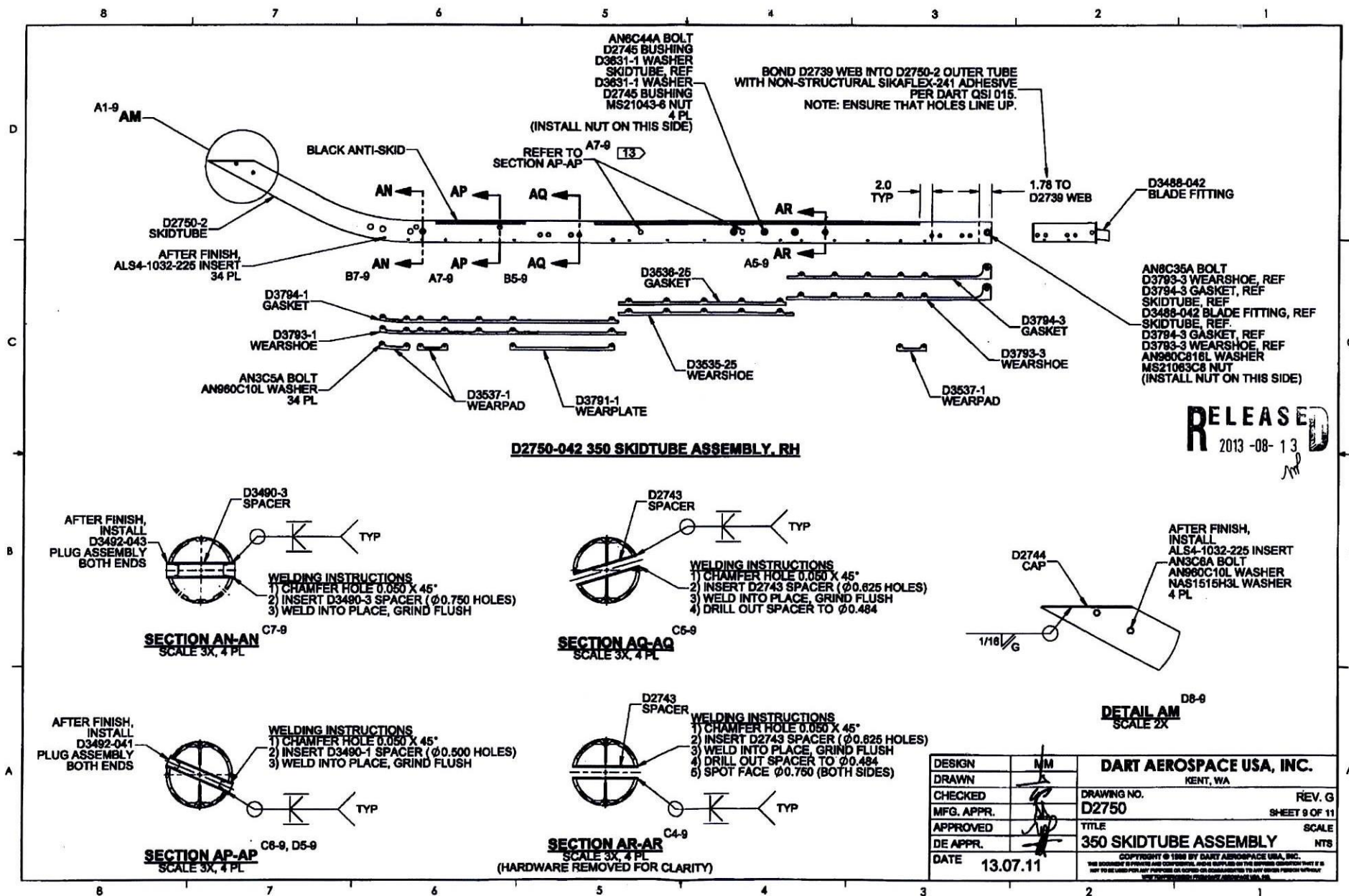


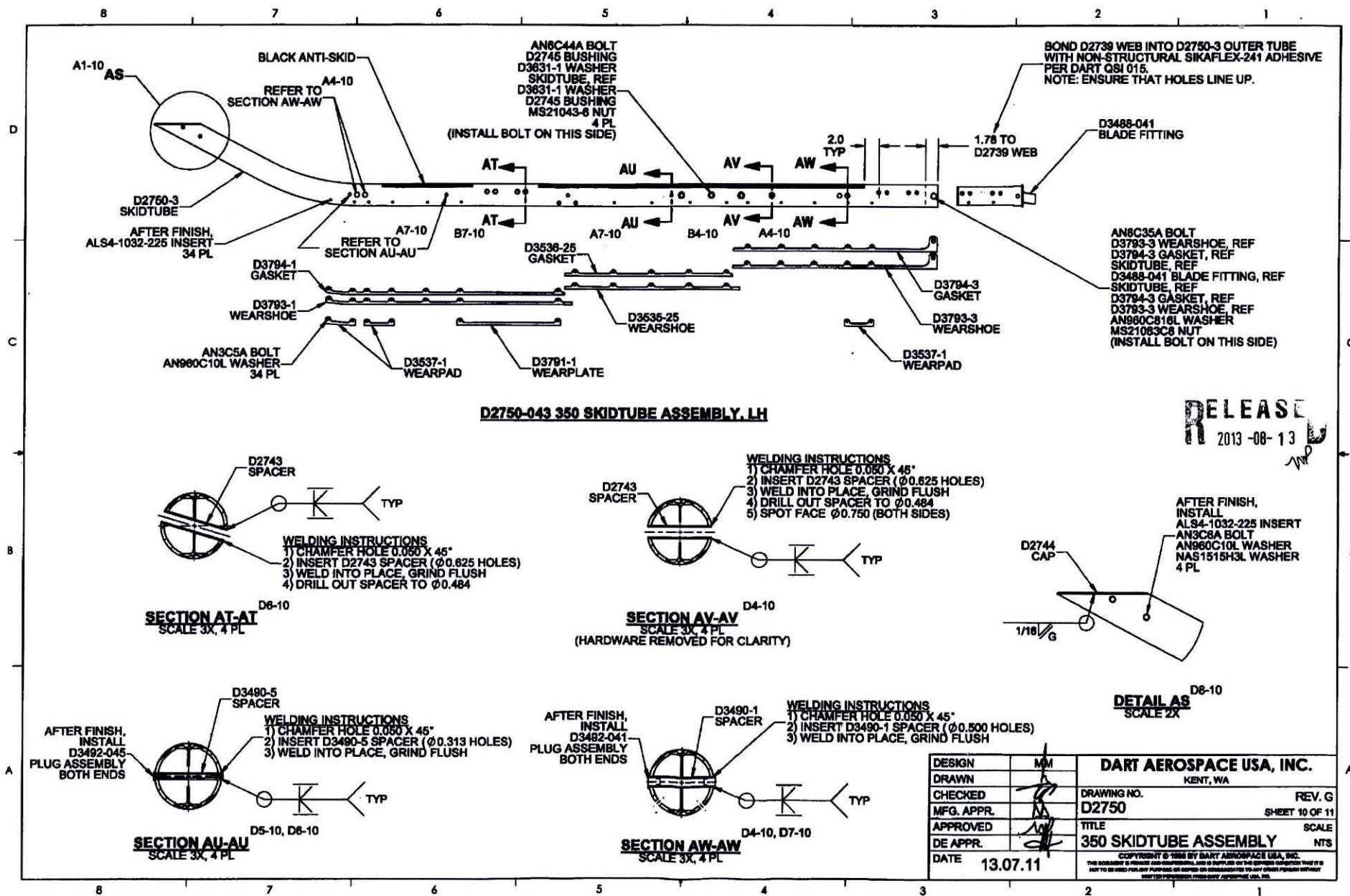
SECTION AF-AF
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SCALE 3X, 4 PL

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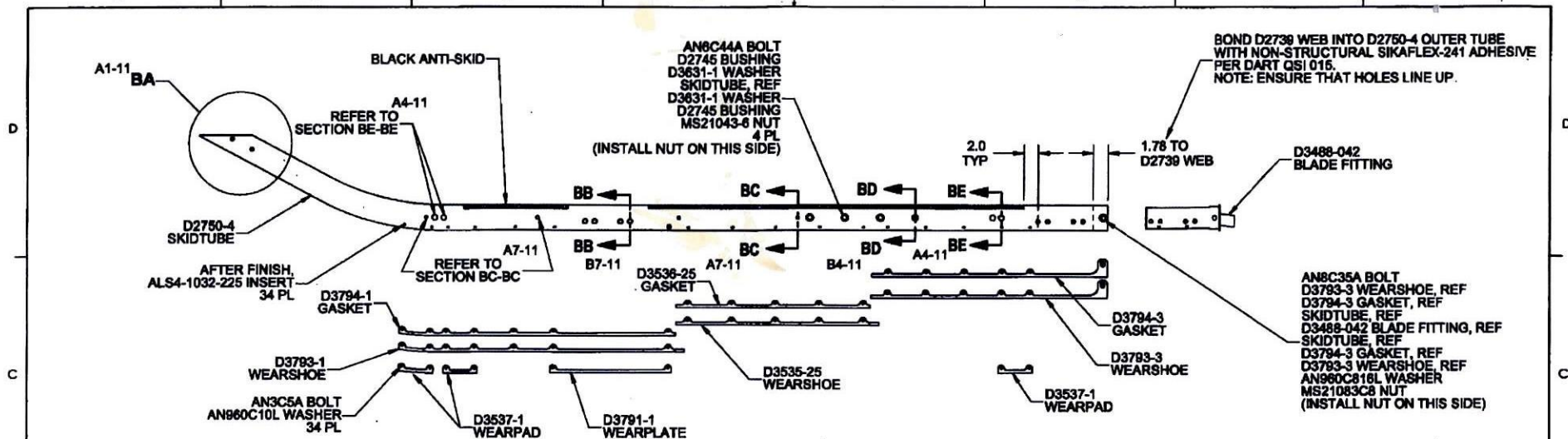
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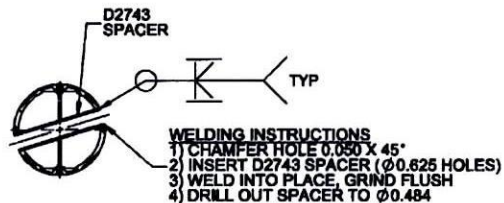




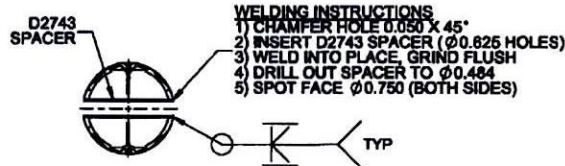
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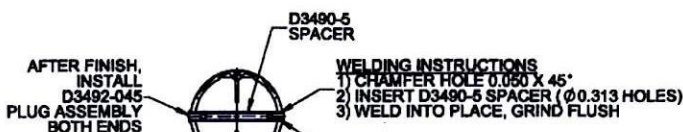
D2750-044 350 SKIDTUBE ASSEMBLY, RH



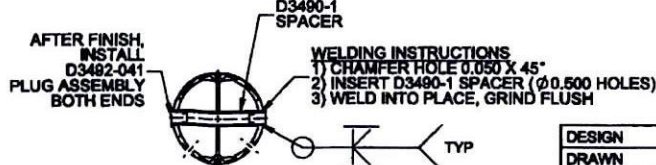
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SCALE 3X, 4 PL



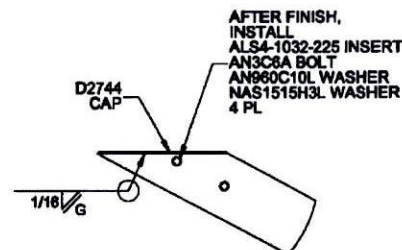
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

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